

Work Order ID 158331

158331

Page 1

Monday, March 20, 2017 11:58:32 AM

Item ID: D412-698-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Handle -Aluminum Door

Start Date: 3/20/2017 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 3/28/2017 Req'd Qty: 3.00 ***3***

Customer:

Reference: SCHEDULED

Approvals: Process Plan: **DAS 21 9-89** Date: **MAR 20 2017** Tooling:

Date:

Run Start ***NR1***

QC: **DAS 21 9-89** Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-698

F

MAR 20 2017

DAS 6 9-89

0.00

100

Document Control

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-698-013CHG001

3

DAS 28 9-89

DAS 21 9-89

MAR 21 2017

170320 3

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3

DAS 6 9-89

MAR 20 2017

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.09

Quality Control

3

DAS 28 9-89

MAR 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 158331***158331***

Page 2

Monday, March 20, 2017 11:58:32 AM

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Start Date: 3/20/2017 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 3/28/2017 Req'd Qty: 3.00 ***3***

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					3	DAS 28 9-89	DAS 27 9-89	MAR 21 2017
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-013 Location:FG022								
	<i>X1 2x sold</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89		MAR 21 2017
QC	Memo	0.30							
Quality Control							DAS 21 9-89		MAR 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date	☐	Manufacturing Process	OTHER :							
Misidentified	☐	Past Due								

Picklist Print

Monday, March 20, 2017 11:58:39 AM

Page 1

Work Order ID: 158331

158331

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 3/20/2017

Required Date: 3/28/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3203-1

Manufactured

No

110

Each

26.0000

4

12

**

D3203-1

Handle

MAR 20 2017

Location

Loc Qty

Loc Code

ST484

26

142048

2

147884

12

155446

12

D3220-041

Manufactured

No

110

Each

7.0000

1

3

**

D3220-041

Doubler Assembly

MAR 20 2017

Location

Loc Qty

Loc Code

ST485

7

140231

1

147997

6

D3220-042

Manufactured

No

110

Each

7.0000

1

3

**

D3220-042

Doubler Assembly

MAR 20 2017

Location

Loc Qty

Loc Code

ST485

7

140140

1

147924

6

DAS
6
9-89

DAS
27
9-89

DAS
6
9-89

DAS
6
9-89

DAS
27
9-89

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Picklist Print

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Work Order ID: 158331

158331

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 3/20/2017

Required Date: 3/28/2017

Start Qty: 3.00

Required Qty: 3.00

D3220-3

Manufactured No

110

Each

7.0000

2

6

D3220-3

Doubler

**

DAS 6 9-89

MAR 20 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST485

7

140035

3

155475

4

2

9

MS21042L4

Purchased

No

110

Each

1,375.000

8

24

MS21042L4

Nut

**

DAS 6 9-89

MAR 20 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

183

m135058

183

OVER007

500

m136986

500

ST303

682

m136450

500

m136838

182

24

MS24694-S98

Purchased

No

110

Each

344.0000

16

48

MS24694-S98

Screw

**

DAS 6 9-89

MAR 20 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

over006

150

m134502

150

ST283

194

m134134

44

m135704

150

4

44

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Page 3

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Work Order ID: 158331

158331

Parent Item: D412-698-013

D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 3/20/2017

Required Date: 3/28/2017

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0416J

Purchased

No

110

Each

3,820.000

8

24

NAS1149D0416.I

WASHER

N/A

Location

Loc Qty

Loc Code

GA

791

m131511

791

ST264

3029

m131511

3029

MAR 20 2017

DAS
6
9-89

DAS
27
9-89

24

MAR 21 08:21

NAS1149A0463J

qty 8

Batch: 136665

MAR 21 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Monday, March 20, 2017 11:58:40 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 158331***158331***

Page 1

Monday, March 20, 2017 1:40:53 PM

Item ID: D412-698-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Handle -Aluminum Door

Start Date: 3/20/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/28/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

F

DAS
21
9-00

MAR 20 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-698-013CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.09

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW